

Date: Monday, 1/8/2007 10:44:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 30141					
Estimate Number	: 10330					
P.O. Number	: N/A			Part Number	: D2746	
This Issue	: 1/8/2007 S.O. No. : N/A			Drawing Number	: D2746 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: 29012			Material	: N/A	
Written By	: <i>JL 07/01/08</i>			Due Date	: 1/30/2007	
Checked & Approved By	: <i>JL 07/01/08</i>			Qty:	50 Um: Each	
Comment	: Est Rev: D 02.10.24 Re-format KJ Est Rev: E 06-03-21 as Per Rev C JLM Est Rev: F 06-06-12 Now On Waterjet JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	WATER JET	FLOW WATER JET
Comment:	FLOW WATER JET	
1-Cut as per Dwg D2746		
Dwg Rev: <u>C</u>	<i>ml 07 03 22</i>	<i>(50) 49</i>
Prog Rev: <u>C</u>		
2-Deburr if necessary		
2.0	M1010S20GA	1010/1025/A21/6aA SHEET
Comment:	Qty.: 0.4263 sf(s)/Unit Total : 21.3150 sf(s) 1010/1025/A21/6aA .040" SHEET (M1010S20GA) Batch: M103840	<i>ml 07 03 22</i>
		<i>(50) 49</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<i>(50) 49</i>
4.0	QC8	SECOND CHECK
Comment:	SECOND CHECK	<i>10/07/07/03 (50) 49</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment:	SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.	<i>ml 07/03/07</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/29	5	1 part missing count 49		?				

NOTE: Date & initial all entries

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Drawing Name: WEARSHOE

Job Number: 30141

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326
2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746

SB 07/03/27
MF 07-03-27

(49)
(49)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7/03-28 (49)

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

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07/03/28 (49)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W-f

07/03/28

(49x)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

ys

07-03-28

(49)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

(49)

Job Completion



87-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30141
Description: Wearshoe	Part Number:	D2746
Inspection Dwg: D2746	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

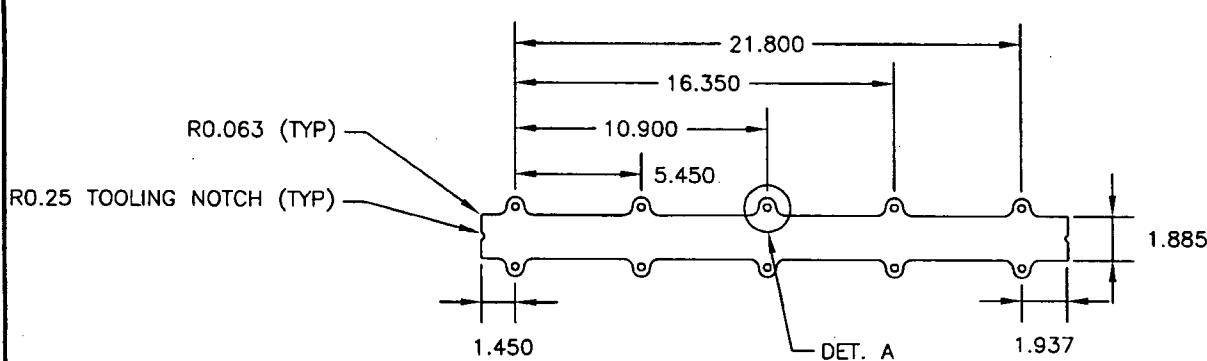
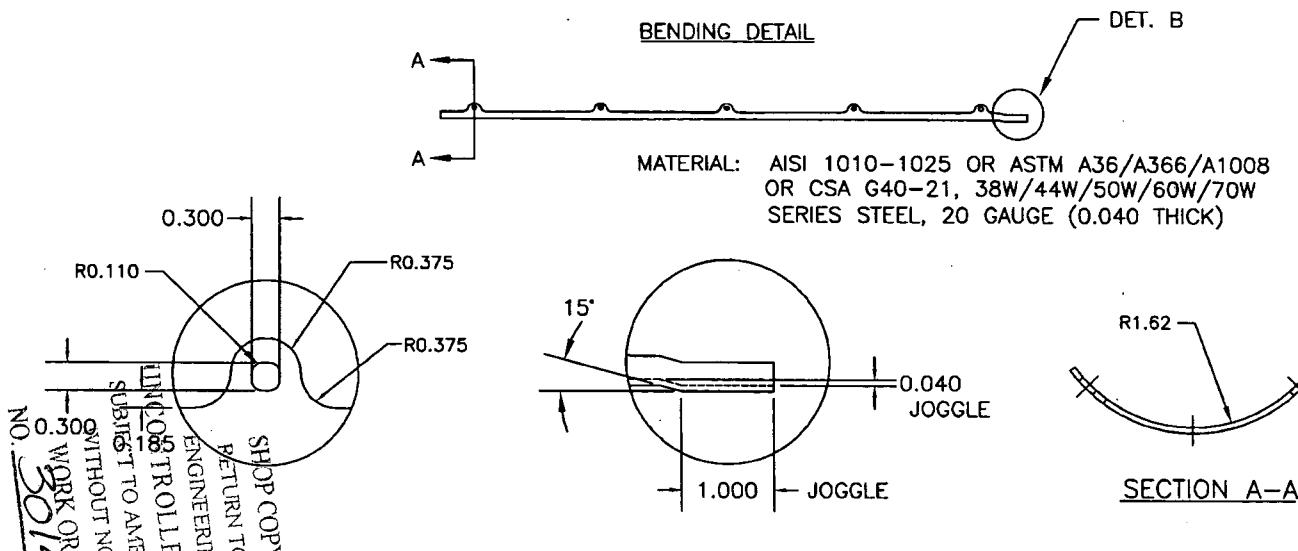
X First Article Prototype

Measured by:	<i>M. M.</i>	Audited by:	<i>A.</i>	Prototype Approval:	N/A
Date:	07/03/22	Date:	07/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	EE

DART**RELEASED**
do 22-07-97

DESIGN <i>P4</i>	DRAWN BY <i>P4</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DATE 06.01.12	APPROVED <i>P4</i>	DRAWING NO. D2746
REV. C	SCALE 1:8	SHEET 1 OF 1
A		TITLE WEARSHOE
B		98.04.16 NEW ISSUE
C		98.08.18 RE-DESIGN
		06.01.12 ENLARGE HOLES TO IMPROVE FIT

FLAT PATTERNBENDING DETAILNOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

1) ~~LINE 1~~ CONTROLLED COPY
2) ~~LINE 2~~ SUBJECT TO AMENDMENT
3) ~~LINE 3~~ WITHOUT NOTICE
4) ~~LINE 4~~ WORK ORDER
NO. 30741